

Work Order ID 65929

Thursday, January 27, 2011 11:27:26 AM

Page 1

Item ID: D3537-3

Accept

Revision ID:

Item Name: Wearpad

Start Date: 1/27/2011 Start Qty: 20.00

Required Date: 2/7/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan:

Date: 1/27/2011 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

RB11-1-28

32

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB11-1-28

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Jul 12s

ccentres
v32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D3537-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearpad					
Start Date:	1/27/2011	Start Qty: 20.00		Cust Item ID:		
Required Date:	2/7/2011	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(32)			
Brake NC	Memo Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 <input type="checkbox"/> Form Joggle as per Dwg D3537 on brake using Jig DT8158	0.00							
				SB 11/02/01					
140 QC	QC5- Inspect part completeness to step on W/O	0.00				count			
Quality Control	Memo Ensure joggle as per dwg D3429	0.00		8 11/02/01		(x32)			
150 Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch <input type="checkbox"/> A/R 2059B Hardcoat								
	M 116631 <input type="checkbox"/> Weld hardcoat as per Dwg D3437								
						EL 11-2-2			(X15)

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Item ID: D3537-3

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Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 1/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		Sub2102					
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sub2102		(415)			
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 m 115128. Memo START TIME: 8:00 300° FINISH TIME: 8:30	0.00 0.00						15 BL 11-023	

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Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 1/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

JL 11/02/03

JL 0

200



Packaging

Packaging

Identify as per dwg & Stock Location: EP-1.7

0.00

Memo

0.00

JL 11/02/03

JL 0

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/03 JF

JF 11-02-03

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Picklist Print

Thursday, January 27, 2011 11:27:32 AM

Page 1

Work Order ID: 65929



Parent Item: D3537-3



Parent Item Name: Wearpad


Start Date: 1/27/2011

Required Date: 2/7/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	254.5000	0.149	3.136842			



B11-1-28

Location

Loc Qty

Loc Code

MAT

254.5

111323

0

116623

254.5

116623

37

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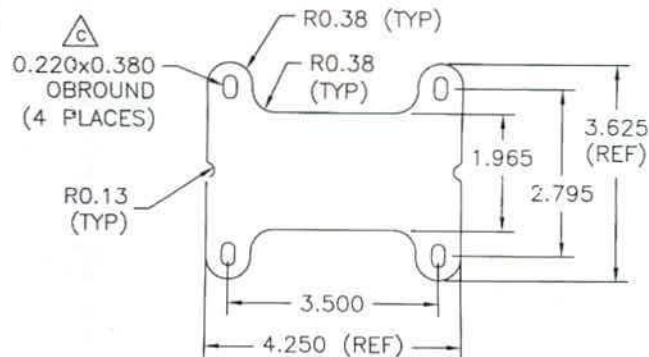
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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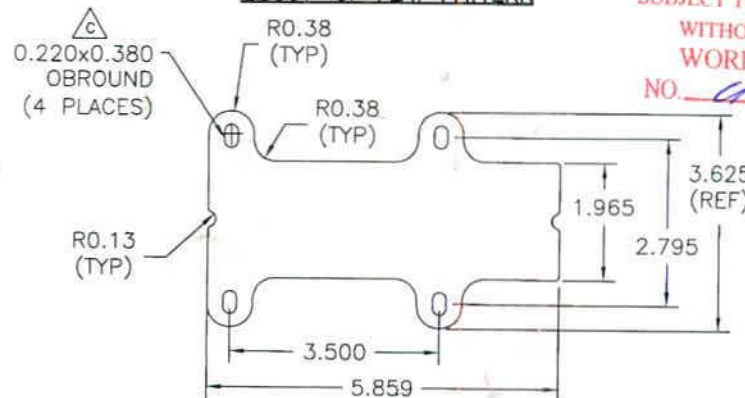
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45929

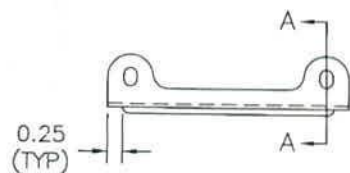
D3537-1F FLAT PATTERN



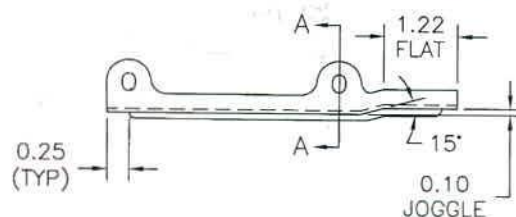
D3537-3F FLAT PATTERN



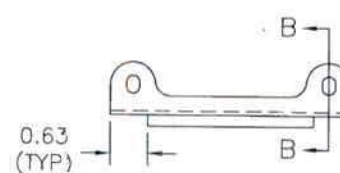
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



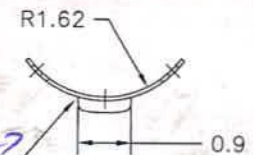
D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)

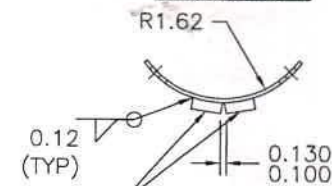


SECTION A-A



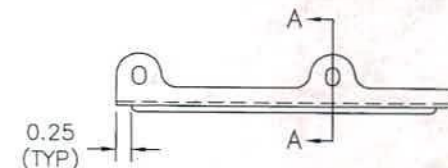
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

RELEASED
07.05.08 PM
PER ELM
952

W/O:		WORK ORDER CHANGES					
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